



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D2435**

**Job Sheet 191948**



Part No: D2435

Job Qty: 12 pcs

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/13/19

Job Tracking No:

Due Date: 3/22/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E1

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                            |
|-------|-----------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------------------------------|
|       |                             |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                     |
| 120   | Waterjet - Omax - 1         | 12 pcs | 3/22/19    | 3/22/19  | 0.00      | 2.00    | Waterjet - Omax       |           | DAS 19/03/14<br>52 19/03/17<br>5-89 |
| 130   | HAAS 4 Axis - B4B           | 12 pcs | 3/22/19    | 3/22/19  | 0.41      | 12.17   | HAAS - 1 - B4B        |           |                                     |
|       |                             |        |            |          |           |         | HAAS - 2 - B4B        |           |                                     |
|       |                             |        |            |          |           |         | HAAS - 3 - B4B        |           |                                     |
|       |                             |        |            |          |           |         | HAAS - 4 - B4B        |           |                                     |
| 150   | QC 8                        | 12 pcs | 3/22/19    | 3/22/19  | 0.00      | 0.00    | QC 8 - 12             |           | amk 19/03/17                        |
|       |                             |        |            |          |           |         | QC 8 - 14             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 17             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 20             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 25             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 3              |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 32             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 33             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 35             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 39             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 4              |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 44             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 45             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 49             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 58             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 8              |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 9              |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 68             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 67             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 1 (A)          |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 47             |           |                                     |
|       |                             |        |            |          |           |         | QC 8 - 40             |           |                                     |
| 151   | Packaging 3-1 - Stock - B4B | 12 pcs | 3/22/19    | 3/22/19  | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           | MAR 18 2019                         |
|       |                             |        |            |          |           |         | Packaging 3 - 2 - B4B |           |                                     |
|       |                             |        |            |          |           |         | Packaging 3 - 3 - B4B |           |                                     |
|       |                             |        |            |          |           |         | Packaging 3 - 4 - B4B |           |                                     |

|                                                                                                                                                                             |                                              |                     |                         |                        |                 |                 |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------|---------------------|-------------------------|------------------------|-----------------|-----------------|
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 5 - B4B  |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 6 - B4B  |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 7 - B4B  |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 8 - B4B  |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 9 - B4B  |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 10 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 11 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 12 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 13 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 14 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 15 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 16 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 17 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 18 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 19 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 20 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 21 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 22 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 23 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 24 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 25 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 26 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 27 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 28 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 29 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 30 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 31 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 32 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 33 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 34 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 35 - B4B |                 |                 |
|                                                                                                                                                                             |                                              |                     |                         | Packaging 3 - 36 - B4B |                 |                 |
| 190 QC 21 - SA                                                                                                                                                              |                                              | 12 pcs              | 3/22/19                 | 0.00 0.00              | QC 21 - SA - 21 |                 |
|                                                                                                                                                                             |                                              |                     |                         |                        | QC 21 - SA - 70 | DAS MAR 18 2019 |
|                                                                                                                                                                             |                                              |                     |                         |                        | QC 21 - SA - 53 | 21              |
| Part Op 120 - Waterjet 2 OMAX (Waterjet 2) CUT BLANK AS PER FILE D2435                                                                                                      |                                              |                     |                         |                        |                 | 3-05            |
| Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435 |                                              |                     |                         |                        |                 |                 |
| 150 - (QC8- Inspect parts - second check)                                                                                                                                   |                                              |                     |                         |                        |                 |                 |
| 151 - (Identify as per dwg & Stock Location:_____)                                                                                                                          |                                              |                     |                         |                        |                 |                 |
| 190 - (QC21- Final Inspection - Work Order Release)                                                                                                                         |                                              |                     |                         |                        |                 |                 |
| Job BOM                                                                                                                                                                     |                                              |                     |                         |                        |                 |                 |
| Part / Item                                                                                                                                                                 | Component Name                               | Quantity            | Operation               | Container              |                 |                 |
| MUHMWB10                                                                                                                                                                    | UHMW 1" Black - 48"x120" Tivar Mfg.#52480104 | 38.4000 sf (3.2 ea) | 120-Waterjet - Omax - 1 | 5143330                |                 |                 |
| Job Allocations                                                                                                                                                             |                                              |                     |                         |                        |                 |                 |
| Operation                                                                                                                                                                   | Component Part                               | Required            | Inventory               | Allocated              |                 |                 |
| 120-Waterjet - Omax - 1                                                                                                                                                     | MUHMWB10                                     | 38                  | 846                     | 0                      |                 |                 |

| Part Specifications |             |                                |                  |                |                  |
|---------------------|-------------|--------------------------------|------------------|----------------|------------------|
| Spec No             | Description | Target/Tolerance               | Limits           | Type           | Special Comments |
| 1                   | Bearpaw     | 0.063Inches + 0.030<br>- 0.010 | 0.093<br>0.053   | 0.063          |                  |
| 2                   | Bearpaw     | 45.000Degrees ± 0.030          | 45.030<br>44.970 | 45° Angle      |                  |
| 3                   | Bearpaw     | 5.500Inches ± 0.030            | 5.530<br>5.470   | 5.500          |                  |
| 4                   | Bearpaw     | 0.200Inches ± 0.030            | 0.230<br>0.170   | 0.200          |                  |
| 5                   | Bearpaw     | 0.250Inches ± 0.010            | 0.260<br>0.240   | 0.250 Radius   |                  |
| 6                   | Bearpaw     | 0.250Inches ± 0.030            | 0.280<br>0.220   | 0.250          |                  |
| 7                   | Bearpaw     | 0.625Inches ± 0.030            | 0.655<br>0.595   | 0.635          |                  |
| 8                   | Bearpaw     | 0.250Inches ± 0.010            | 0.260<br>0.240   | 0.250          |                  |
| 9                   | Bearpaw     | 45.000Degrees ± 0.000          | 45.000<br>45.000 | 45° Angle      |                  |
| 10                  | Bearpaw     | 0.375Inches ± 0.010            | 0.385<br>0.365   | 0.380          |                  |
| 11                  | Bearpaw     | 19.000Inches ± 0.030           | 19.030<br>18.970 | 19.000         |                  |
| 12                  | Bearpaw     | 0.950Inches + 0.030<br>- 0.010 | 0.980<br>0.940   | 0.960          |                  |
| 13                  | Bearpaw     | 0.260Inches + 0.005<br>- 0.000 | 0.265<br>0.260   | 0.260 Diameter |                  |
| 14                  | Bearpaw     | 0.930Inches ± 0.030            | 0.960<br>0.900   | 0.932 Diameter |                  |
| 15                  | Bearpaw     | 0.300Inches + 0.030<br>- 0.000 | 0.330<br>0.300   | 0.315          |                  |
| 16                  | Bearpaw     | 0.375Inches ± 0.030            | 0.405<br>0.345   | 0.375          |                  |
| 17                  | Bearpaw     | 7.375Inches ± 0.030            | 7.405<br>7.345   | 7.375          |                  |
| 18                  | Bearpaw     | 4.250Inches ± 0.010            | 4.260<br>4.240   | 4.250          |                  |
| 19                  | Bearpaw     | 2.000Inches ± 0.030            | 2.030<br>1.970   | 2.000          |                  |
| 20                  | Bearpaw     | 9.000Inches ± 0.010            | 9.010<br>8.990   | 9.000          |                  |
| 21                  | Bearpaw     | 15.750Inches ± 0.030           | 15.780<br>15.720 | 15.750         |                  |

Plex 3/13/19 1:15 PM dart.lacelle.linda

DAS  
52  
9-89

19/03/16



**Container No: S163061**



**Part: D2435**

**Job No: 191948**

**Serial No/Batch: S163061**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

**Date: 03/15/19**